



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE703A94-1130-01-27

Job Sheet 187711



Part No: RBE703A94-1130-01-27

Job Qty: 10 ea

Part Name: Tab Adjuster Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/12/18

Job Tracking No:

Due Date: 1/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A94-1130-01 REV K IPP Rev.A 17.08.09 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/10/19	1/10/19	0.00	0.00	Start Up Machining-1		P.J. 19-01-20
105	Bandsaw	10 pcs	1/10/19	1/10/19	0.00	1.00	Bandsaw1		P.J. 19-01-20
110	Mori Seiki	10 pcs	1/10/19	1/10/19	0.00	10.00	NV5000-1		P.J. 19-01-20
120	QC	10 pcs	1/10/19	1/10/19	0.00	0.00	QC2 Machining-4		P.J. 19-01-20
130	QC	10 pcs	1/10/19	1/10/19	0.00	0.00	QC8 Machining-4		P.J. 19-01-20
150	Outsource	10 pcs	1/10/19	1/10/19			ATG001-VC	10	P.J. 19-01-20
160	Packaging	10 pcs	1/10/19	1/10/19	0.00	0.00	Packaging2		P.J. 19-01-20
170	QC	10 pcs	1/10/19	1/10/19	0.00	0.00	QC6		P.J. 19-01-20
180	Packaging	10 pcs	1/10/19	1/10/19	0.00	0.00	Packaging3-1		P.J. 19-01-20
190	QC21-SA	10 Ea	1/10/19	1/10/19	0.00	0.00	QC21		P.J. 19-01-20

Part Op 105 - Cut blanks at 4.25"

Descriptions: 110 - 1-Machine as per folio FB582 FOLIO REV: AA DWG REV: K 2-Debur

120 - Engrave T/N number using Marktronic engraver as per DWG.

150 - Issue P/O to ATG: 200-1245 - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X01.500	6061-T6 Bar 2.50 X 1.50	3.5000 ft (.35 ea)	90-Start up Operation	S124463

Job Allocations

Component Part	Required	Inventory	Allocated
31T6B2.500X01.500	4	42	0

Part Specifications

Specifications could not be found.



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S146424



Part: RBE703A94-1130-01-27

Job No: 187711

Serial No/Batch: S146424

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 01/22/19

Plex 12/12/18 8:04 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					

DART AEROSPACE LTD		Work Order:	187711
Description: Tab adjuster body		Part Number:	ABE703A94-1130-21-27
Inspection Dwg:	Rev: K	Page 1 of 1	

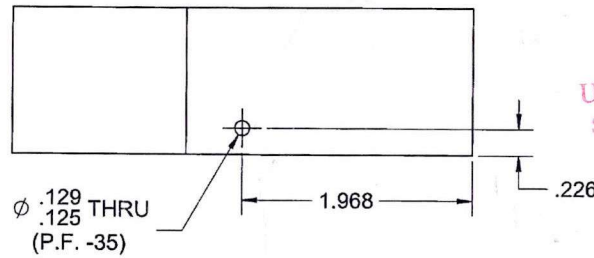
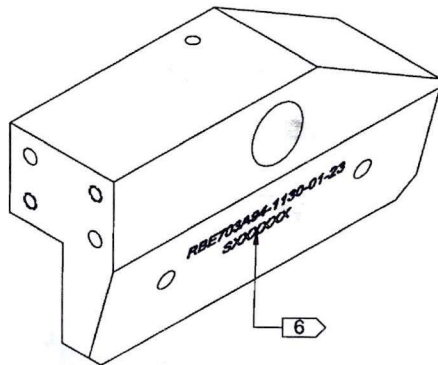
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.787	H/- .001	.787	✓		mcob	
.217	H/- .005	.214	✓		mcob	
R.06	H/- .010	.062	✓			
M4 x .07	go/no go	go	✓		go/no go	
I.40	H/- .010	.370	✓		mcob	
.472	H/- .001	.472	✓		mcob	
.236	H/- .005	.233	✓		mcob	
Ø.1567/.1571	N/A	.1567	✓		pin	
.472	H/- .005	.470	✓		mcob	
1.024	H/- .005	1.023	✓		mcob	
.787	H/- .005	.795	✓		mcob	
2.362	H/- .005	2.360	✓		mcob	
1.181	H/- .005	1.180	✓		mcob	
3.94	H/- .010	3.940	✓		mcob	
.945	H/- .005	.946	✓		mcob	
Ø.6094/.610	N/A	.610	✓		pin	
Ø.125/.129	N/A	.126	✓		pin	
1.968	H/- .005	1.963	✓		mcob	
.226	H/- .005	.224	✓		mcob	
1.260	H/- .005	1.261	✓		mcob	
2.205	H/- .005	2.205	✓		mcob	
.640	H/- .005	.642	✓		mcob	
.913	H/- .005	.920	✓		mcob	
75°	H/- .5°	74.7	✓		block	
M6 x 1	go/no go	go	✓		go/no go	

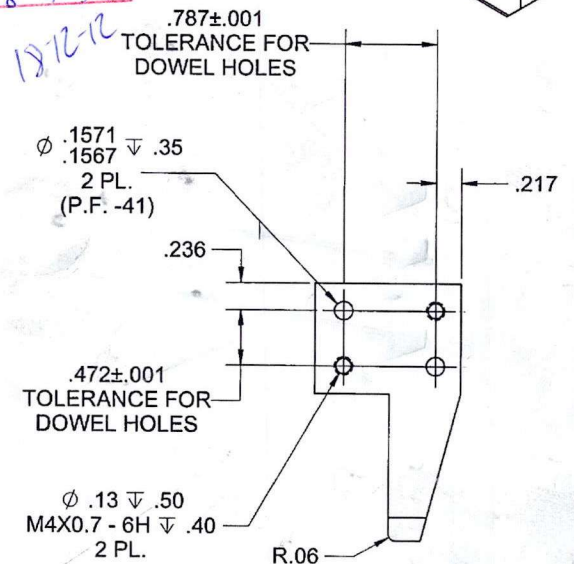
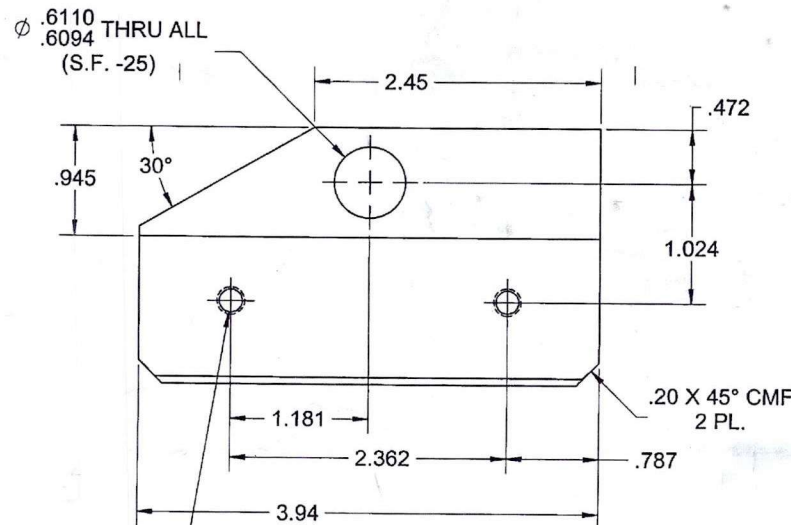
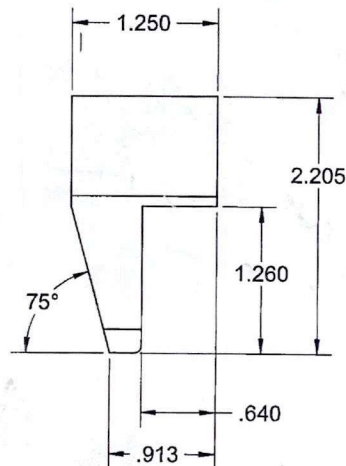
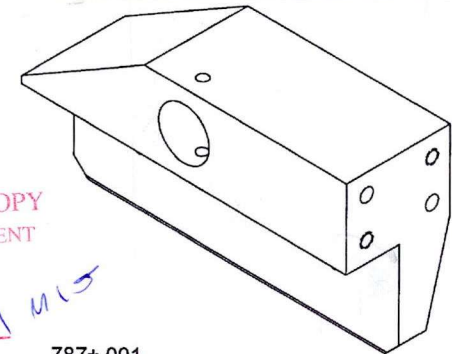
Measured by: P.T	Checked by: m/mc	QC Inspector:
Date: 17-01-21	Date: 19/01/28	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187711



NOTES:

- 1) MATERIAL: 6061-T6
- 2) FINISH: CLEAR ANODIZE
- 3) HEAT TREAT: N/A
- 4) SPEC: MIL-A-8625, TYPE II, CLASS 1; WATER SEALANT
- 5) BREAK ALL SHARP EDGES .015 X 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE T/N & S/N PER CAD FILE "RBE703A94-1130-01-27 LATEST REV, 0.010" DEPTH

RBE703A94-1130-01-27 TAB ADJUSTER BODY

DART AEROSPACE Hawkebury, Ontario, Canada	
TITLE TAB ADJUSTER BODY	
DWG NO. RBE703A94-1130-01-27	
DESIGN BY: VM 8/28/2017	XXX ± .005 FRACTIONS & 1/8 ANGLES & 5° SURFACES & 12°
DRAWN BY: VM 11/24/2017	X ± .01
CHECKED BY: VM 11/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
MFG. APPR: VM 11/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED BY: VM 11/30/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
DATE: 11/24/2017	
SCALE: NTS	WEIGHT: 0.546LBS
SHEET 11 OF 17	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042445



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042445
PO Date: 1/30/19
Due Date: 2/11/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189112	RBT112800-3	PTO Seal Install Tool -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	-	2/11/19	26 pcs	0 pcs	26 pcs	\$4.64/pcs	\$120.64
2	187711	RBE703A94-1130-01-27	Tab Adjuster Body -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required	Firmed	-	2/11/19	11 pcs	0 pcs	11 pcs	\$4.64/pcs	\$51.04



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PURCHASE ORDER PO042445



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189111	RBT112800-1	Base (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As per Dwg RBT112800 Rev. 3A -Certificate of Conformity is required	Firmed	-	2/11/19	16 pcs	0 pcs	16 pcs	\$4.64/pcs	\$74.24
4	188311	646.3810	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	2/11/19	17 pcs	0 pcs	17 pcs	\$5.56/pcs	\$94.52



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PURCHASE ORDER

PO042445



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	R189819	RBD29904-RWRevB	Hoist Adapter "D" Model -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$4.64/pcs	\$4.64

1x

FEB 08 2019

B

Line Item Note ** ASAP URGENT AHH! **

Grand Total: \$345.08

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CZ

Plex 2/8/19 2:28 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917223

Date: 08-Feb-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 26 ea	Part: RBT112800-3 Rev: 3A PTO Seal Install Tool Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils) Water Seal Job: 24604 PO: PO042445 Line: 1		
✓ 11 ea	Part: RBE703A94-1130-01-27 Rev: 6 Tab Adjuster Body Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24605 PO: PO042445 Line: 2		
✓ 16 ea	Part: RBT112800-1 Rev: 3A Base Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils) Water Seal Job: 24606 PO: PO042445 Line: 3		
✓ 17 ea	Part: 646.3810 Rev: NC Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24607 PO: PO042445 Line: 4		
✓ 1 ea	Part: RBD29904 Rev: A Hoist Adapter "D" Model Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24608 PO: PO042445 Line: 5		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Made in Canada.		



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917223

Date: 08-Feb-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Date: <u>8/2/19</u>		
	Certified Signature: _____		
	Receiver Signature: _____		
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.		
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
	Made in Canada.		